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RB23003267-3
Job Sheet 197217



Part No: RB23003267-3

Job Qty: 2 pcs *4 MLL*

Part Name: #56 Drill Bit & Block Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/3/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/5/19

Description:

Type: Stock

Note: DWG RB23003267 Rev.4 IPP Rev. A 19.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	8/5/19		0.00	0.25	Small Fab - 1		<i>MLL</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	2 pcs	8/5/19		0.00	0.00	QC 5 - 10		<i>DAS 81 9-89</i>
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
120	Small Fab - 2 - B4B	2 pcs	8/5/19		0.00	0.20	Small Fab - 1 - B4B		<i>JUL 29 2019</i>
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		



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Container No: S199655



Part: RB23003267-3

Job No: 197217

Serial No/Batch: S199655

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 07/22/19

125 QC 5	2 pcs	8/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
130 Packaging 3-1 - Stock - B4B	2 pcs	8/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	2 pcs	8/5/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

DAS
28
9-89

DAS
21
9-89

JUL 2 9 27 19

Part Op 100 - Assemble as per drawing using LOC TITE multipurpose epoxy.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - Laser engrave as per drawing

125 - QC5- Inspect part completeness to step on W/O

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB23003267-3A	#56 Drill Bit	2 pcs (1 ea)	100-Small Fab - 1	5199045
RB23003267-3B	Block	2 pcs (1 ea)	100-Small Fab - 1	5160902

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RB23003267-3A	2	0	0
	RB23003267-3B	2	4	0

Part Specifications

Specifications could not be found.

Plex 7/3/19 8:44 AM Dart.lajeunesse.marie

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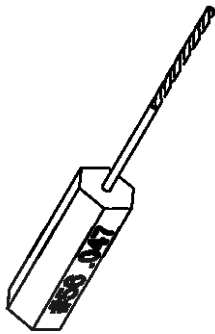
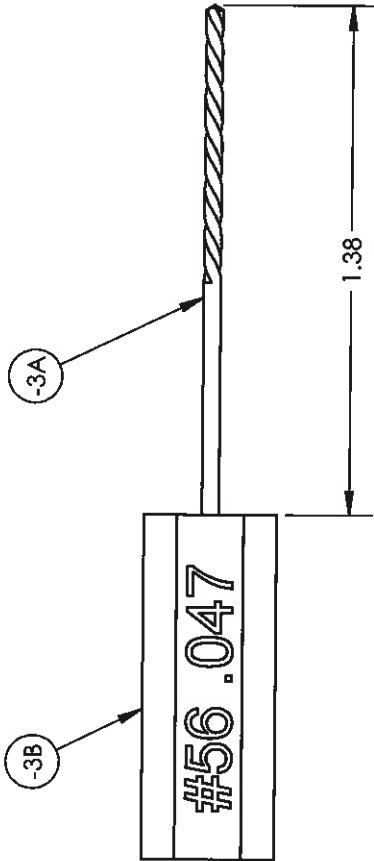
REVISIONS
DESCRIPTION

REV ECR

DATE

INITIAL

APPROVED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197217 MJS
1907-03

NOTE:
ASSEMBLE WITH EPOXY.

DART
AEROSPACE

TITLE
POWER TURBINE CLEANING KIT

DWG NO. RB23003267-3 REV 4

MAT'L
HEAT TREAT
FINISH
SPEC
DRAWN BY: CLOUGH
CHECKED: CLOUGH
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: GILBERT
SCALE 2:1
DATE 1/17/2001
SHEET 3 OF 18

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS $\pm 1/8$
XXX $\pm .005$
XX $\pm .01$
X $\pm .1$
ANGLES $\pm .5^\circ$
SURFACES = 125/ $\sqrt{\text{R}}$
1. BREAK ALL SHARP EDGES
TO .015 X 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
UNLESS OTHERWISE SPECIFIED
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

-3

#56 DRILL BIT ASSEMBLY

USED ON MODEL

SEE NOTE 1, SHEET 1

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality							
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors				FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled				Other/Details: ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											